

Work Order ID 133367

Monday, June 08, 2015 11:10:21 AM

133367

RUSH

Page 1

Item ID: D5194-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler
 Start Date: 6/8/2015 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 6/8/2015 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUN 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5194	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
<i>6061 .032</i>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

(10)

DC 15/06/09

(10)

DC 15/06/09

(10)

DAS
38
JUN 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition																					
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 NC BRAKE Memo	0.00 0.00				(10)	✓	06/15/06/10	
140 *140* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				(10)			DAS 38 9-89 JUN 12 2015
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: 5T149 Memo	0.00 0.00				10	10		JUN 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 133367

Monday, June 08, 2015 11:10:21 AM

133367

Page 3

Item ID: D5194-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 6/8/2015

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/8/2015

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS

JUN 12 2015

MCS

JUN 12 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause		FAULT CATEGORY			
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Picklist Print

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Parent Item: D5194-1

D5194-1

Parent Item Name: Doubler

Start Date: 6/8/2015

Required Date: 6/8/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.12.03 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

sf

142.7213

⑦

M6061T6S 032

6061-T6 Sheet 0.032"

**

De 15/06/09

Location

Loc Qty

Loc Code

MAT021

142.7213

m130387

35.0667

m130585

19.6546

m131352

88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause		FAULT CATEGORY			
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

8

7

6

5

4

3

2

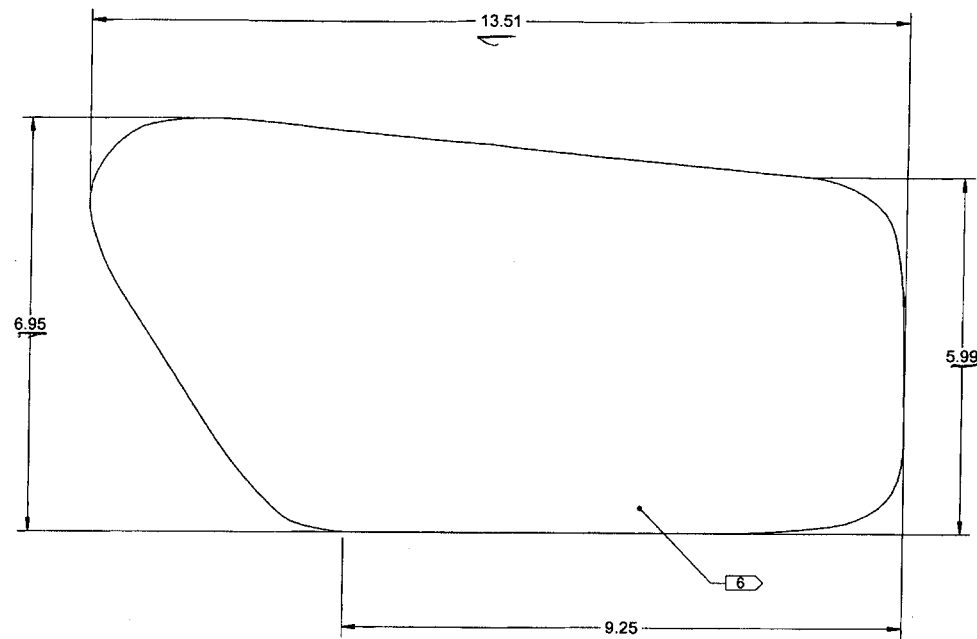
1

D

C

B

A

**D5194-1 DOUBLER****NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.24 lbs
- 8) CUT PER D5194-1.DXF. NON-DIMENSIONED FEATURES CONTROLLED BY D5194-1.SLDPRT

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SUBJECT TO AMENDMENT

NOTICE

WORK ORDER

133367 MLJ

15-06-08

RELEASED

2015 APR 30

47 ECU 15.527

APPROVED	A	NEW ISSUE	AK	14.11.20
	REV.	DESCRIPTION	BY	DATE
	DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AK		
	CHECKED	RF	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5194	SHEET 1 OF 1
APPROVED			TITLE	SCALE
DE APPR.			DOUBLER	NTS
DATE			14.11.20	

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